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D5369-1
Job Sheet 199357



Part No: D5369-1

Job Qty: 5 pcs

Part Name: Cable Guard



Part Weight: 0 lbs

Job Created: 8/20/19

Due Date: 9/6/19

Type: SOLD

Note: DWG REV A IPP REV:A 15.12.09 NEW ISSUE DD VERF:JLM

Ship Via:

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	5 pcs	9/6/19	9/6/19	0.00	0.50	Bandsaw - 1		mm 2019/08/23 9:40
110	HAAS 4 Axis - B4B	5 pcs	9/6/19				HAAS - 1 - B4B		mm 2019/08/23 9:40
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	5 pcs	9/6/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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				QC 2 - 8		
				QC 2 - 66		
				QC 2 - 64		
				QC 2 - 65		
				QC 2 - 5		
				QC 2 - 71		
				QC 2 - 73		
				QC 2 - 69		
130 QC 8	5 pcs	9/6/19	0.00 0.00	QC 8 - 12		
				QC 8 - 14		
				QC 8 - 17		
				QC 8 - 20		
				QC 8 - 25		
				QC 8 - 3		
				QC 8 - 32		
				QC 8 - 33		
				QC 8 - 35		
				QC 8 - 39		
				QC 8 - 4		
				QC 8 - 44		
				QC 8 - 45		
				QC 8 - 49		
				QC 8 - 58		
				QC 8 - 8		
				QC 8 - 9		
				QC 8 - 68		
				QC 8 - 67		
				QC 8 - 1 (A)		
				QC 8 - 47		
				QC 8 - 40		
				QC 8 - 52		
				QC 8 - 23		
				QC 8 - 57		
140 Packaging 3-1 - Stock - B4B	5 pcs ✓	9/6/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		

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Mon 8-26-2019
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					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150 QC 21 - SA	5 pcs ✓	9/6/19	0.00	0.00	QC 21 - SA - 21 →	ST 479 A
	Mon 8-26-2019	Qscr			QC 21 - SA - 70	DAS 70
					QC 21 - SA - 53	9-89
Part Op 100 - CUT TO 82.750"						
Descriptions: 110 - (HAAS CNC Vertical Machine), 1-Mill as per folio FB443 & dwg D5369, FOLIO REV: AA DWG REV: A						
2-Deburr as required						
120 - (QC2- Inspect parts off machine FAI/FAIB)						
130 - (QC8- Inspect parts - second check), ENSURE D5369-1/-2 IS MACHINED TO LENGTH AS PER DWG.						
140 - (Identify as per dwg & Stock Location:_____)						
150 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
MUHMWB1.750X1.000X96.00	UHMW 1.75x1.00x96.00 (Tolerance +/- .010) order	32.6000 ft (6.52 ea)	100-Bandsaw	S143388		
	120"		- 1			
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Bandsaw - 1	MUHMWB1.750X1.000X96.00	33	98	0		
Part Specifications						
Specifications could not be found.						

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Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QSI042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐
		Completed By _____			
		Lead hand / Supervisor _____			
		QC / QA Coordinator _____			

DART AEROSPACE LTD		Work Order:	
Description: Cable Guard		Part Number: D5369 X 1	
Inspection Dwg: D5369 Rev: A		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.06	+0.020/-0.000	.065				
0.13 x 45°	+/-0.030 x +/-0.5°	0.125 x 45°	✓		Vern. 2° Finder	
1.44	+/-0.030	1.44	✓		Vern.	
0.31	+/-0.030	.316	✓		high gauge	
24°	+/-0.5°	24°	✓		2° Finder	
50°	+/-0.5°	50°	✓		2° Finder	
0.54	+/-0.030	0.54	✓		Vern.	
0.31	+/-0.030	.315	✓		high gauge	
0.48	+/-0.030	.488	✓		vernier	
0.87	+/-0.030	.878	✓		vernier	
1.75	+/-0.030	1.750	✓		Vern.	
Ø0.316	+0.006/-0.001	.316	✓		Pin gauge	
2.00	+/-0.030	2.005	✓		vernier	
1.63	+/-0.030	1.619	✓		vernier	
0.29	+/-0.030	.287	✓		vernier	
7.65	+/-0.030	7.647	✓		vernier	
8.03	+/-0.030	8.03	✓		vernier	
8.78	+/-0.030	8.878	✓		vernier 12 gauge	
9.26	+/-0.030	9.255	✓		vernier 12 gauge	
12.03	+/-0.030	12.03	✓		vernier 12 gauge	
12.78	+/-0.030	Tape	✓		Tape	
13.16	+/-0.030	13.150	✓			
20.71	+/-0.030	20.690	✓			
25.71	+/-0.030	25.690	✓			
43.71	+/-0.030	43.690	✓			
61.71	+/-0.030	61.690	✓			
65.66	+/-0.030	65.650	✓			
72.76	+/-0.030	72.750	✓			
73.00	+/-0.030	73.00	✓			
76.09	+/-0.030	76.070	✓			
76.92	+/-0.030	Tape 76.925	✓		Tape	
78.12	+/-0.030	78.12			Tape	

Measured by: M.M. DAS 64	Checked by: [Signature]	QC Inspector:
Date: 2019/08/22	Date: 19/08/23	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	16.03.30	New Issue	KJ [Signature]	[Signature]